

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012581**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

7BW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 13 and 14 located at DP639-001 on the counter weight side of segment. Welder is identified as Mr. Ji Yunfeng (067589). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 18 and 17 located at DP647-001 on the cross beam side of segment. Welder is identified as Mr. Zang Quanfa (066326). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 049 located at SEG035 on the cross beam side of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

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Shield Metal Arc Welding (SMAW) welding was performed on weld joint 001 located at CA032 on the cross beam side of segment. Welder is identified as Mr. Li Zai Jun (037996). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

7CW

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 007 located at SEG037A on the cross beam side of segment. Welder is identified as Mr. Jiang Jinyong (066361). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 004 located at SEG037A on the counter weight side of segment. Welder is identified as Mr. Luo Xuanping (067610). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-2214-Tc-U4b-FCM-1.

Shield Metal Arc Welding (SMAW) welding was performed on weld joint 11 and 12 located at DP648-001 on the cross beam side of segment. Welder is identified as Mr. Zang Quanfa (066326). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-T-4114-1.

7AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 001 located at CA032 on the cross beam side of segment. Welder is identified as Mr. Li Zaijun (037996). ZPMC QC is identified as Wu Zhi Cheng. The welding variables monitored and recorded by the QC appeared to comply with WPS-B-P-2212-B-U2-FCM-1.

6AW

Shield Metal Arc Welding (SMAW) repair welding was performed on weld joint 307 located at SEG027\* on the deck plate diaphragm to floor beam flange at panel point 38. Welder is identified as Mr. Yang Yunfeng (045221). ZPMC QC is identified as Li Yang. The welding variables monitored and recorded by the QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and WR10982 repair procedure.

Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

5 East

Segment was removed from Trail Assembly yard and placed at the heavy dock staging area for shipment.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (150-0042-2372), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller,Mark	QA Reviewer

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